

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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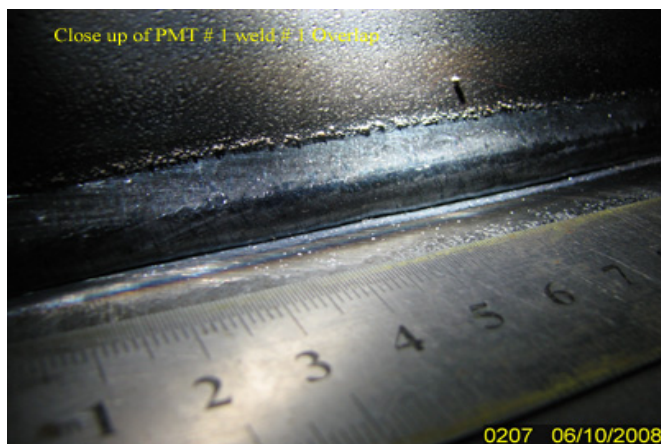
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002943**Date Inspected:** 09-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Wang Sai Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to monitor activities associated with the Production Monitoring Test of Orthotropic Box Girder (OBG) Deck Panel U-rib welds, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP552-001 and DP597-001. The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. A Visual inspection of the root pass and cover pass was performed by ZPMC, American Bridge Flour (ABF) and the Caltrans QA. The first PMT was rejected by ZPMC Quality Control (QC) for overlap on the cover pass of weld # 6. An additional PMT was fabricated and visual of the root pass and cover pass were accepted by ZPMC, ABF and the Caltrans QA Inspector. Ultrasonic testing for Penetration depth was performed by ZPMC QC Xue Hai Rong. Mr. Xue found the welds of the 2nd PMT to be compliant with applicable contract documents. The Caltrans QA inspector designated locations for Macroetch samples. ZPMC were in the process of etching samples at the end of the shift. Please the attached photo of the overlap area of weld # 001 rejected by ZPMC.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
